

Work Order ID 61226

August 11, 2010 11:05:53 AM



Page 1

Item ID:	D2933-1UP	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206 Saddle Left-unpainted					
Start Date:	8/11/10	Start Qty:	6.00	Cust Item ID:		
Required Date:	8/25/10	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>10/8/11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2933	Rev C

100		HAAS CNC VERTICAL MACHINING #1	0.00						
HAAS 1		Memo	0.00						
HAAS CNC vertical machine #1		Program part number and batch number. <input type="checkbox"/> 1-Inspect part number and batch number are programmed correctly. <input type="checkbox"/> 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet <input type="checkbox"/> 3-Machine Step No 2 of Folio and visually inspect as per							
				<u>ITP</u>	<u>10/09/18</u>	<u>6</u>	<u>0</u>		
110		CONVENTIONAL MILLING MACHINE	0.00						
Mill Conv		Memo	0.00						
Conventional Milling Machine		Machine Keyway and inspect per attached dimension sheet							
				<u>ITP</u>	<u>10/09/18</u>	<u>6</u>	<u>0</u>		
120		QC1- Inspect dimensions to dimension sheet	0.00						
QC		Memo	0.00						
Quality Control				<u>ITP</u>	<u>10/09/18</u>	<u>6</u>	<u>0</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		2L 10/09/19					
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		el 10/09/21		6	4		
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		BR 10-9-21		6	4		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries


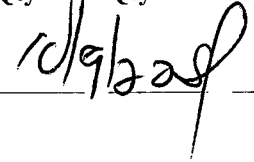

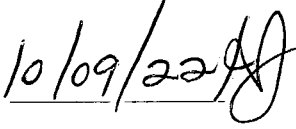
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Revision ID: Stop 
Item Name: 206 Saddle Left-unpainted
Start Date: 8/11/10 Start Qty: 6.00  Cust Item ID:
Required Date: 8/25/10 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>431</u> Memo	0.00 0.00							<u>10/9/22</u> 
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/09/22</u>  MF 10-9-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 61226



Parent Item: D2933-1UP



Parent Item Name: 206 Saddle Left-unpainted



Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	41.0000	1	6			
Saddle Billet													

Location

Loc Qty

Loc Code

MAT
46409

MAT40
46409

36
36

5
5

6.0 H.A 10/09/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	61226
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140	deep Mic 118-120	0.125	0.123	0.124	0.124	0.123
B	0.100	0.140	"	0.121	0.122	0.121	0.122	0.122
C	0.100	0.140	"	0.129	0.126	0.129	0.128	0.129
D	0.210	0.230	Mic DTP-02	0.225	0.223	0.222	0.223	0.223
E	1.245	1.255	Vern DTP-11	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255	"	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505	"	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515	"	0.510	0.510	0.510	0.510	0.510
I	1.572	1.582	"	1.577	1.577	1.577	1.577	1.577
J	2.495	2.505	"	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262	"	0.259	0.259	0.259	0.259	0.259
L	0.312	0.317	"	0.317	0.316	0.316	0.316	0.316
M	0.235	0.240	Mic DTP-02	0.237	0.237	0.238	0.238	0.238
N	0.100	0.140	"	0.111	0.118	0.117	0.119	0.118
O	0.540	0.560	Vern DTP-11	0.541	0.549	0.547	0.547	0.547
P	0.490	0.510	"	0.500	0.497	0.496	0.496	0.496
Q	3.715	3.725	"	3.720	3.720	3.720	3.720	3.720
R	2.470	2.510	"	2.493	2.493	2.493	2.495	2.495
S	0.240	0.270	"	0.248	0.245	0.246	0.246	0.2455
T	0.100	0.180	"	0.135	0.135	0.135	0.135	0.135
U	1.625	1.635	"	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372	"	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321	"	0.318	0.318	0.318	0.318	0.318
X	1.125	1.145	Dial	1.1385	1.139	1.138	1.139	1.1395
Y	1.565	1.585	"	1.575	1.575	1.574	1.575	1.576
Z	0.178	0.198	Rad Gage	0.188	0.188	0.188	0.188	0.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: DTP	Date: 10/09/18
Audited by: JL	Date: 10/09/18
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

DART AEROSPACE LTD		Work Order:	61226
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

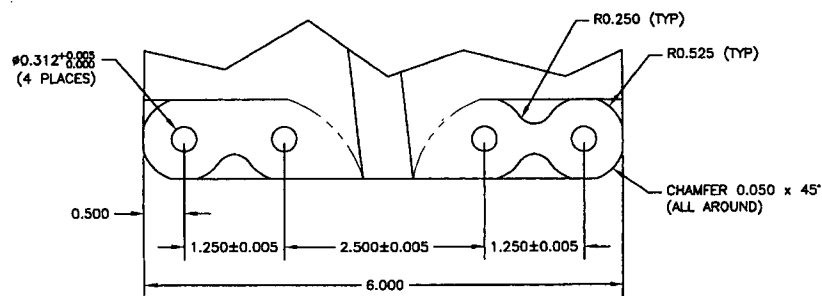
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	2	3	4	5
A	0.100	0.140		0.121				
B	0.100	0.140		0.124				
C	0.100	0.140		0.129				
D	0.210	0.230		0.223				
E	1.245	1.255		1.250				
F	1.245	1.255		1.250				
G	2.495	2.505		2.500				
H	0.510	0.515		0.510				
I	1.572	1.582		1.577				
J	2.495	2.505		2.500				
K	0.257	0.262		0.259				
L	0.312	0.317		0.316				
M	0.235	0.240		0.237				
N	0.100	0.140		0.118				
O	0.540	0.560		0.547				
P	0.490	0.510		0.497				
Q	3.715	3.725		3.720				
R	2.470	2.510		2.495				
S	0.240	0.270		0.245				
T	0.100	0.180		0.135				
U	1.625	1.635		1.630				
V	1.362	1.372		1.367				
W	0.316	0.321		0.318				
X	1.125	1.145		1.139				
Y	1.565	1.585		1.576				
Z	0.178	0.198		0.188				
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	10/09/18
Audited by:	<i>[Signature]</i>	Date:	10/09/18
Prototype Approval:	N/A	Date:	N/A

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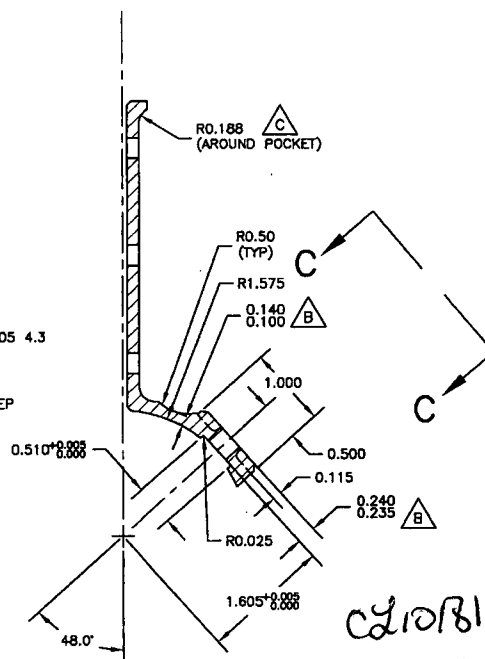


VIEW C-C

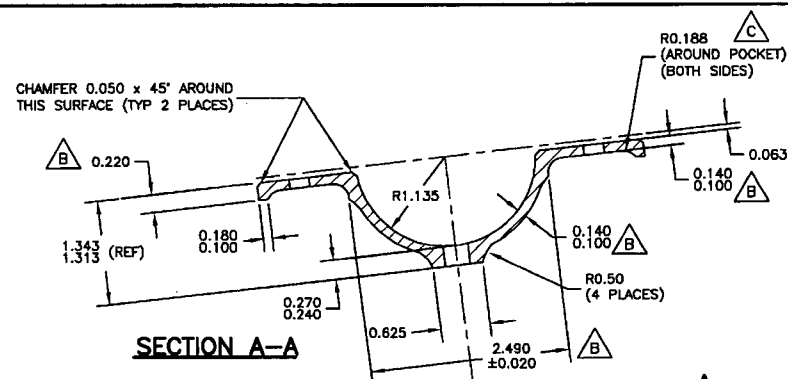
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

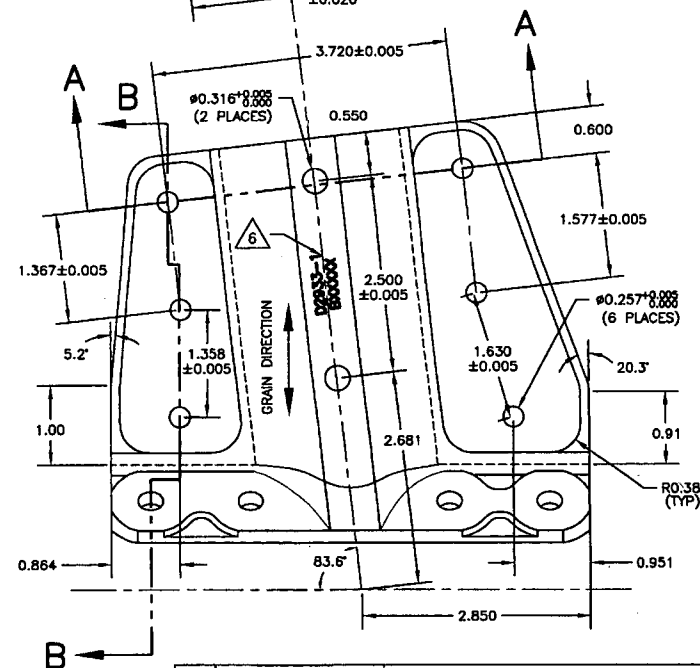
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	D2933
DATE	06.11.09	SADDLE INSIDE

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07-02-12

07-02-12

C210B111
W10:61226

REV. C

SHEET 1 OF 1

SCALE

2.3